

Work Order ID 47520

July 1, 2009 2:44:35 PM



Page 1

Item ID: D3514-047

Accept



Setup Start



Revision ID: A

Stop



Item Name: Top Mounted Housing Assembly

Start Date: 07/15/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 09/09/21 Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3514

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D3514

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

120

0.00



Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Powdercoat

Memo

0.00

Powder Coating

START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

Work Order ID 47520

July 1, 2009 2:44:35 PM

Page 2

Item ID: D3514-047

Accept

Revision ID: A

Item Name: Top Mounted Housing Assembly

Start Date: 07/15/2009 Start Qty: 2.00

Required Date: 08/03/2009 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

140

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Assemble trim as per dwg D3514

150

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control



Cust Item ID:

Customer:



2009/10/01 (2)

(42) /

2009/10/01

Work Order ID 47520

July 1, 2009 2:44:35 PM



Page 3

Item ID: D3514-047

Accept



Setup Start



Revision ID: A

Stop



Item Name: Top Mounted Housing Assembly

Start Date: 07/15/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: C-A

0.00



Packaging

Memo

0.00

Packaging

Eff 09/10/01

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/01
MF 09-10-01

Picklist Print

July 1, 2009 2:44:34 PM

Work Order ID: 47520

Parent Item: D3514-047RevA

Parent Item Name: Top Mounted Housing Assembly


Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3526-1RevA		Manufactured	No			100	Each	1.0000	2.0000			
												
Rubber Seal												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1	
35377	1	

see
original
w/o
mf
09-10-01

Date: Monday, 27/04/2009 12:50:53 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	GPS RECEIVER HOUSING	
Job Number :	47520			
Estimate Number :	12517			
P.O. Number :		Part Number :	D3514047	
This Issue :	27/04/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D3514 REV.A	
First Issue :	1/1	Project Number :	N/A	
Previous Run :	45563	Drawing Revision :	A	
		Material :		
Written By :		Due Date :	15/05/2009	Qty: 2 Um: Each
Checked & Approved By :	<u>Julie Dawson 09.04.27</u>			
Comment :	Est Rev:A New Issue 07-09-24 EC verified by DD			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	✓ D35143	Box Top (Top Mounted)
-----	----------	-----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOX TOP (BOTTOM MOUNTED)

Batch: B35374

9/6/11

50

2.0	✓ D35147	Box Bottom (Top Mounted)
-----	----------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOX BOTTOM (BOTTOM MOUNTED)

Batch: B345713

9/6/11

50

3.0	✓ D35149	Hood
-----	----------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

HOOD

Batch: B35376

9/6/11

50

4.0	✓ D3524041	Upper Plate Assembly
-----	------------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

UPPER AND LOWER PLATE

Batch: B324824

9/6/11

56

5.0	✓ MS20426AD33	Rivet
-----	---------------	-------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

RIVET

Batch: M7681

9/6/11

50

(2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 12:50:53 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 47520

Part Number: D3514047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

✓ MS20426AD44

Rivet



Comment: Qty.: 11.0000 Each(s)/Unit Total : 22.0000 Each(s)

Rivet

Batch: M15541

9/6/11

SLP

7.0

✓ MS20426AD49

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

RIVET

Batch: M18136

9/6/11

SLP

8.0

✓ MS21072L06

ANCHOR NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

ANCHOR NUT

Batch: M101760

9/6/11

SLP

9.0

✓ SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3514

FF 09-06-16

PTO

(2)

10.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/06/16

(12)

11.0

✓ POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 10:00am

OVEN TEMPERATURE: 320°C

FINISH TIME: 10:30am

SL

09-06-17

(2)

12.0

✓ QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

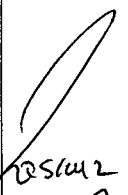

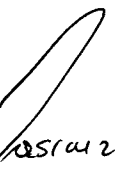

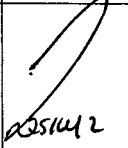

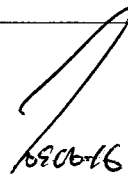
BL 09-06-17

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
29/06/16	9	1 rivet was oblong removed, step after rivet was covered & hole over-sized. RC: Human error.		replace rivet At an attempt to fill the hole with weld, the material became porous. D3524-041 is now scrap.	RS 29/06/16			
				replace 1x D3524-041 B 34824				

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 12:50:54 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 47520

Part Number: D3514047

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0



SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble trim as per dwg D3514

09/10/01 (2)

14.0



D35261

Rubber Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

RUBBER SEAL

Batch: *335377 B 50249*

SO 07/05/30 (2)

15.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sort 4061 (2)

16.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

17.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

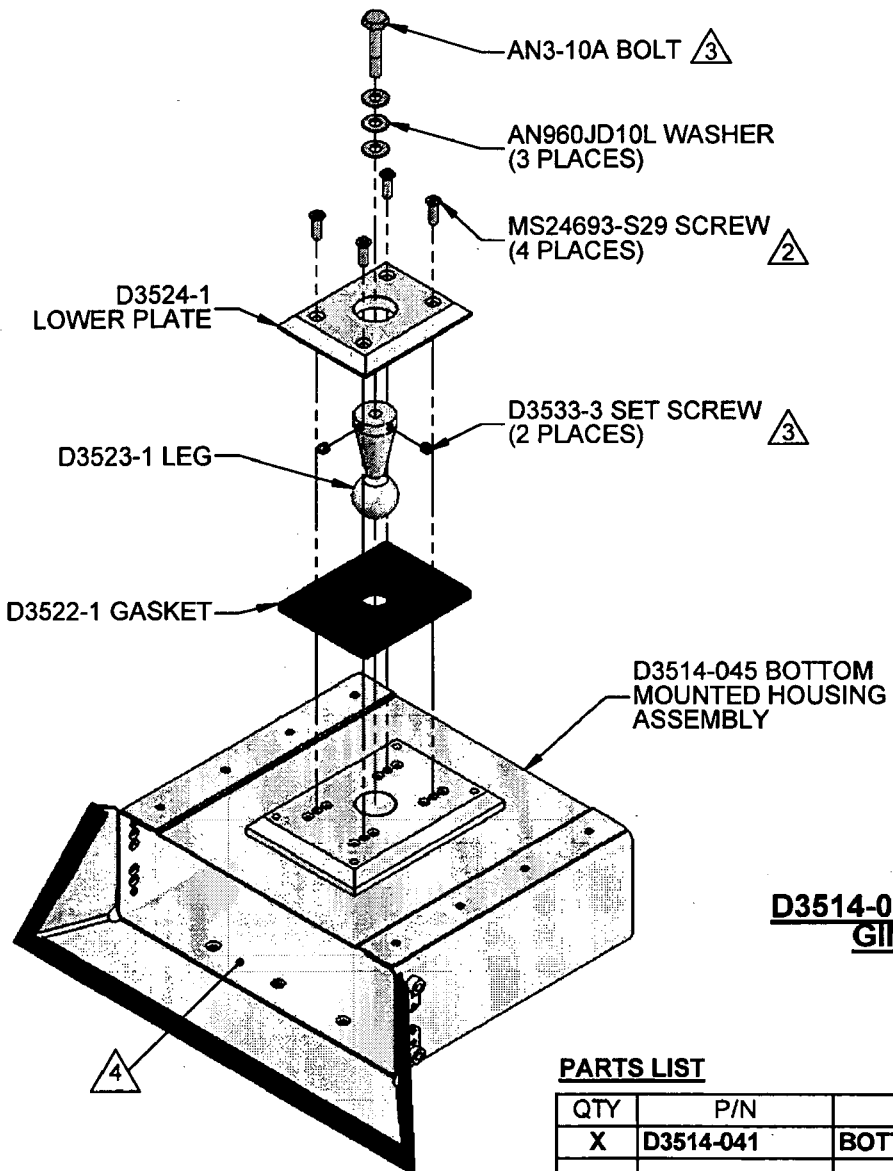
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514	REV. A SHEET 1 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING		SCALE 1:3
REV A	DATE 07.06.18	DESCRIPTION NEW ISSUE	



RELEASED
07.08.07

**D3514-041 BOTTOM MOUNTED
GIMBAL ASSEMBLY**

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. A-1500

PARTS LIST

QTY	P/N	DESCRIPTION	NO.
X	D3514-041	BOTTOM MOUNTED GIMBAL ASSEMBLY	
1	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY	
1	D3522-1	GASKET	
1	D3523-1	LEG	
1	D3524-1	LOWER PLATE	
2	D3533-3	SET SCREW	
1	AN3-10A	BOLT	
3	AN960JD10L	WASHER	
4	MS24693-S29	SCREW	

NOTE:

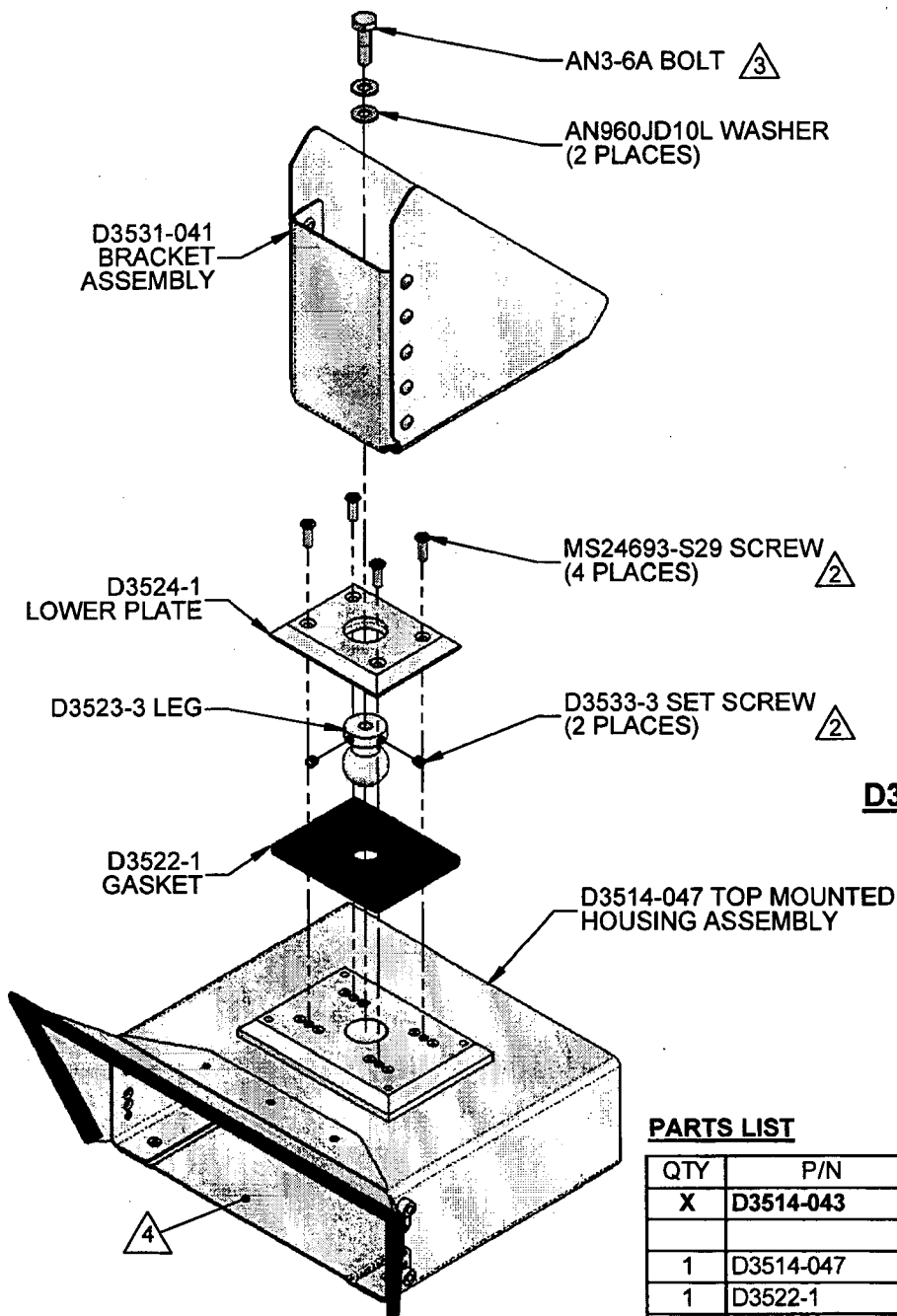
- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TIGHTEN TO SNUG FIT ONLY
- 4) IDENTIFY WITH DART P/N "D3514-041" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

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DATE 07.06.18	TITLE GPS RECEIVER HOUSING		SCALE 1:3



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07.08.03

**D3514-043 TOP MOUNTED
GIMBAL ASSEMBLY**

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WORK ORDER
NO. 47520

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-043	TOP MOUNTED GIMBAL ASSEMBLY
1	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-3	LEG
1	D3524-1	LOWER PLATE
1	D3531-041	BRACKET ASSEMBLY
2	D3533-3	SET SCREW
1	AN3-6A	BOLT
2	AN960JD10L	WASHER
4	MS24693-S29	SCREW

NOTE:

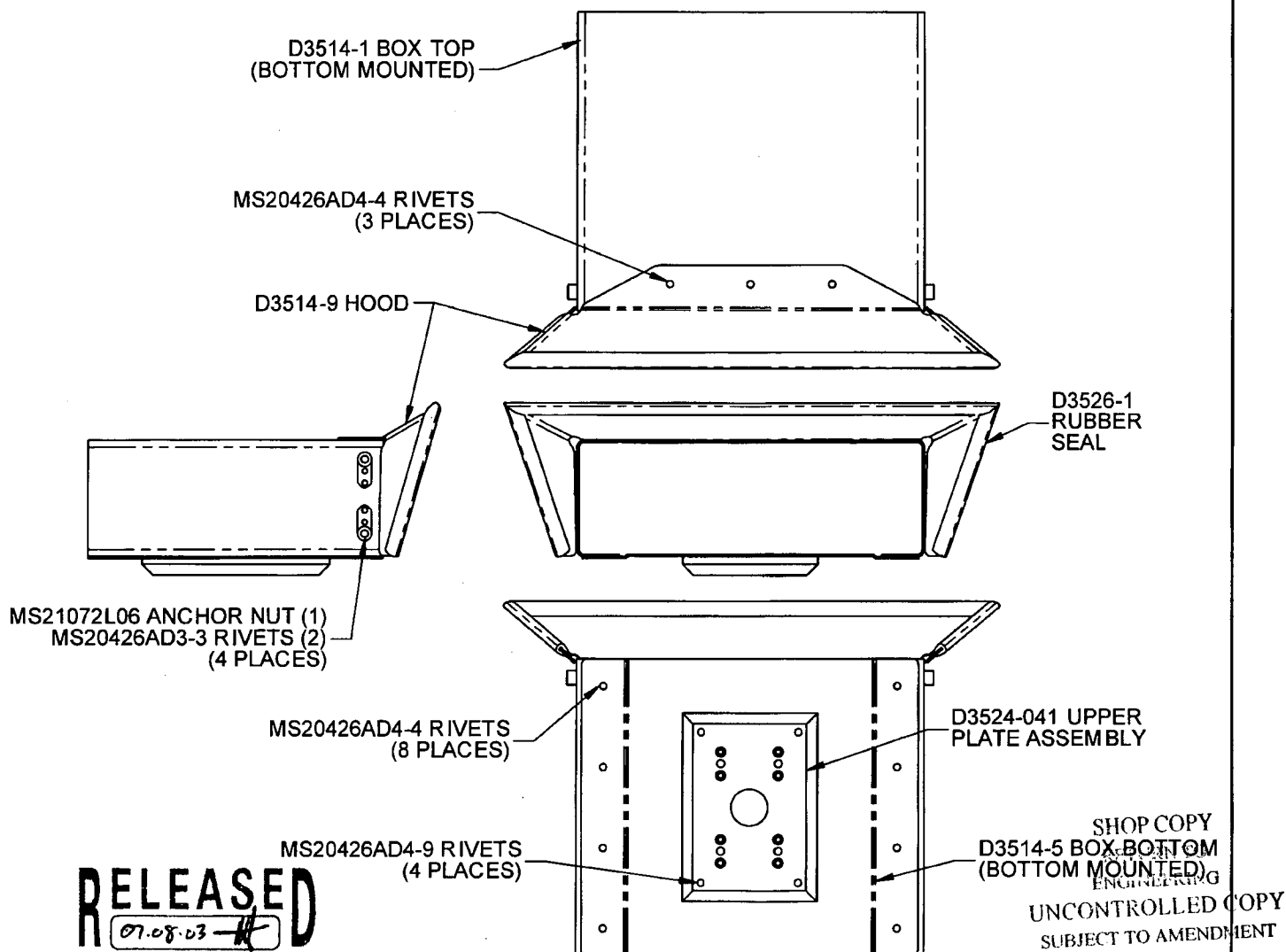
- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TORQUE BOLTS TO 15-25 in-lbs
- 4) IDENTIFY WITH DART P/N "D3514-043" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3



**D3514-045 BOTTOM MOUNTED
HOUSING ASSEMBLY**

NOTES:

- 1) POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

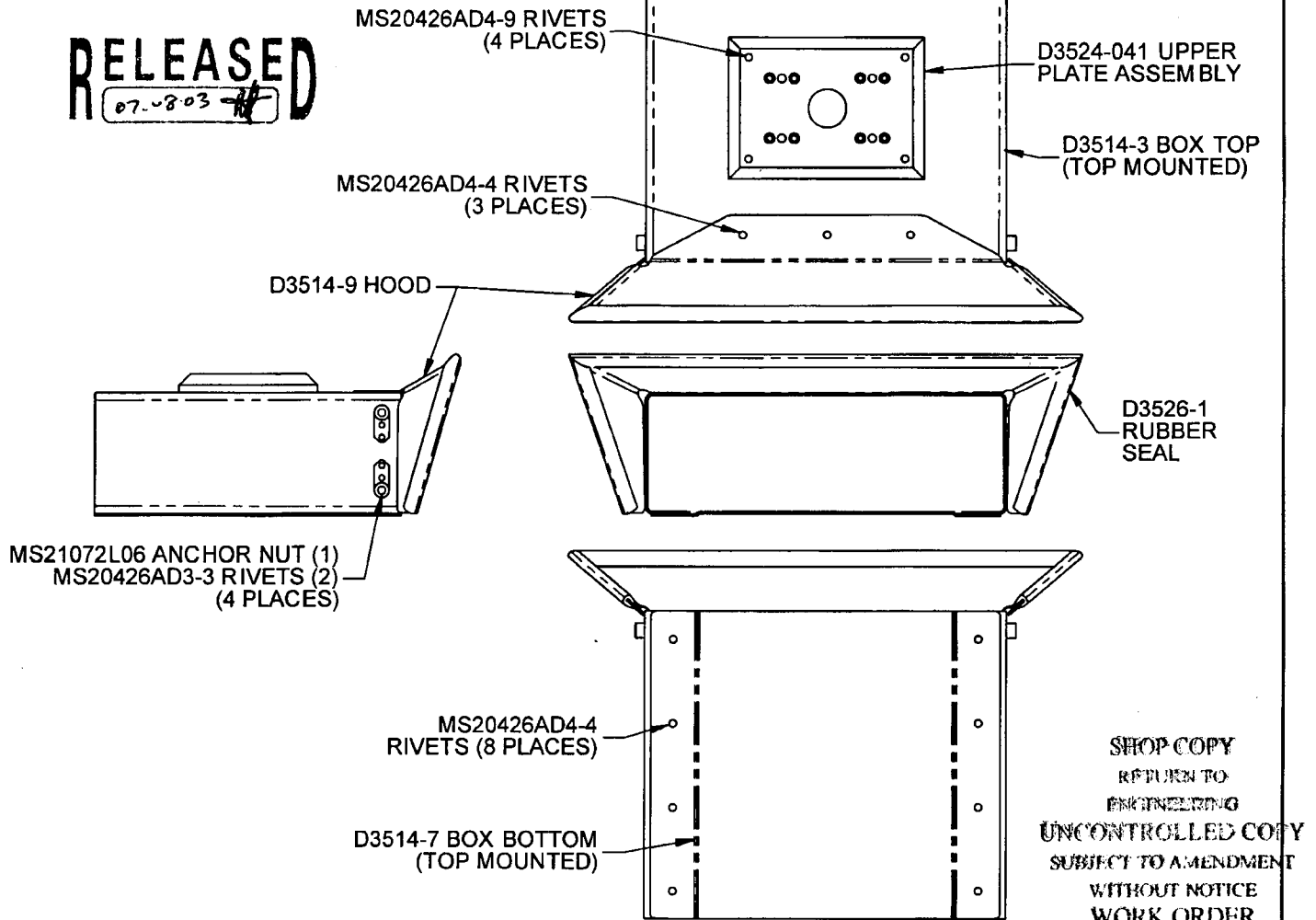
QTY	P/N	DESCRIPTION
X	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3514-1	BOX TOP (BOTTOM MOUNTED)
1	D3514-5	BOX BOTTOM (BOTTOM MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3

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07-08-03

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WORK ORDER
NO. **47520**

**D3514-047 TOP MOUNTED
HOUSING ASSEMBLY****NOTES:**

- 1) POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3514-3	BOX TOP (TOP MOUNTED)
1	D3514-7	BOX BOTTOM (TOP MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

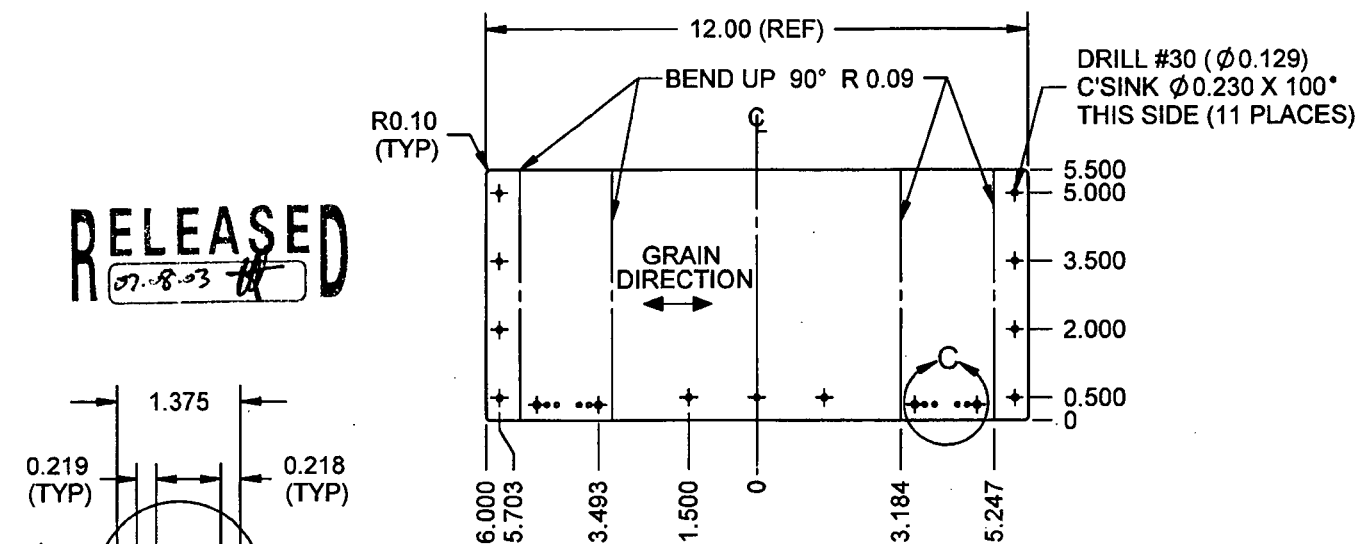
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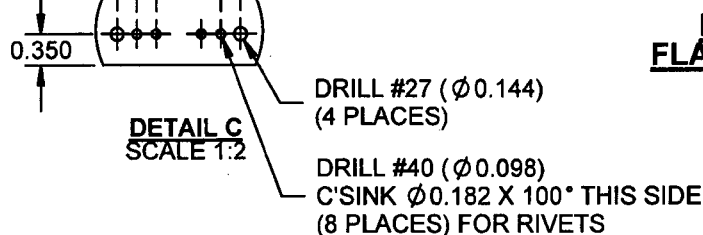
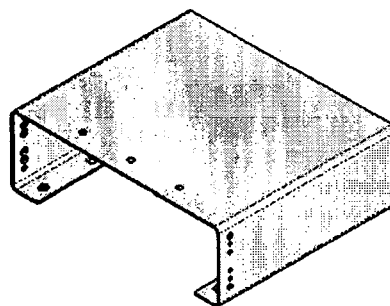


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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514	REV. A SHEET 5 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING		SCALE 1:4

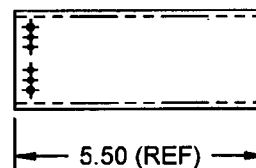
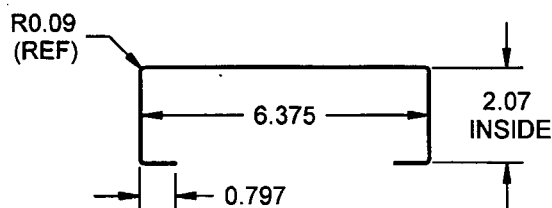
RELEASED
07-08-03 [Signature]



**D3514-1F
FLAT PATTERN**



**DETAIL C
SCALE 1:2**



D3514-1 BOX TOP (BOTTOM MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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WORK ORDER
NO. 47500

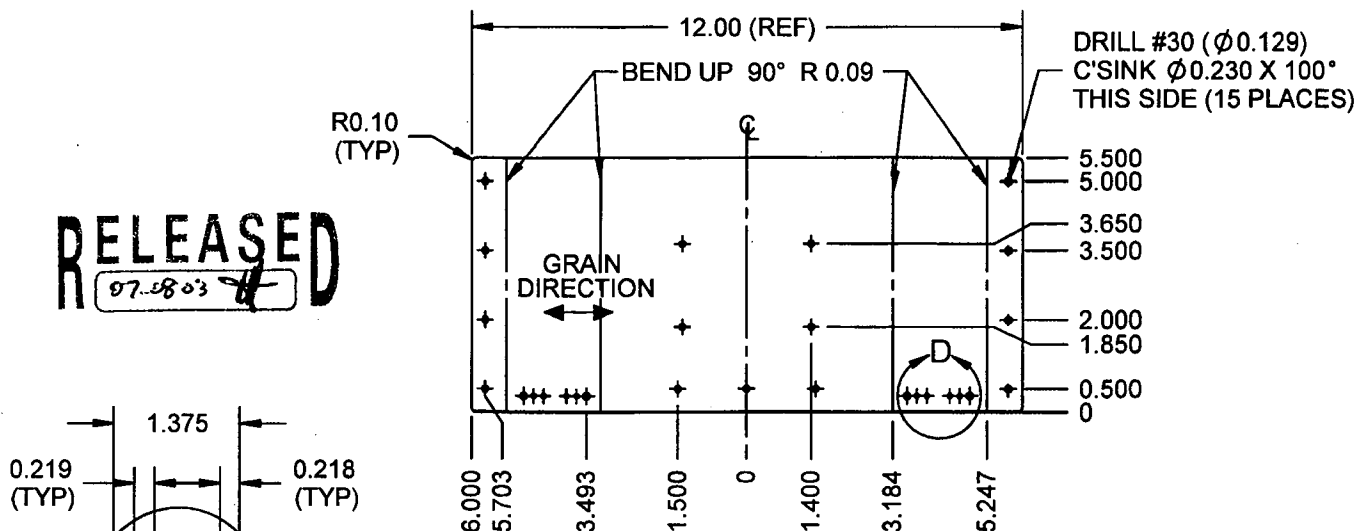
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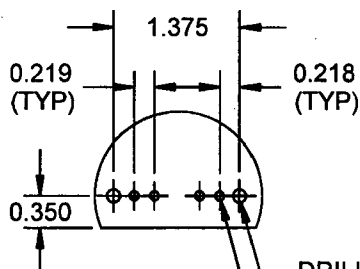


DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514
DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 6 OF 9 SCALE 1:4

RELEASED
07-08-03



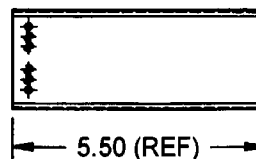
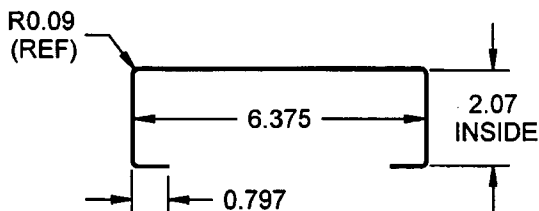
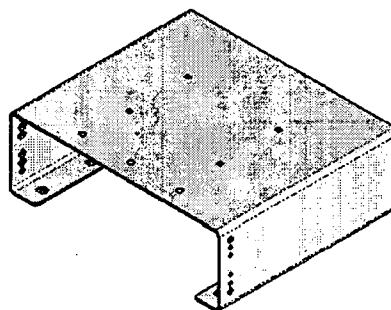
**D3514-3F
FLAT PATTERN**



**DETAIL D
SCALE 1:2**

DRILL #27 (Ø0.144)
(4 PLACES)

DRILL #40 (Ø0.098)
C'SINK Ø0.182 X 100° THIS SIDE
(8 PLACES) FOR RIVETS



D3514-3 BOX TOP (TOP MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

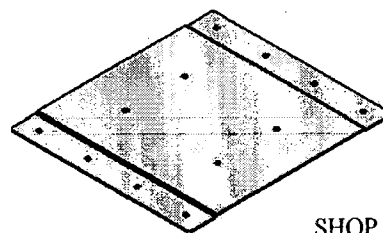
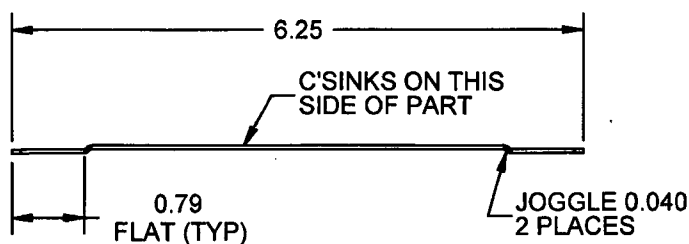
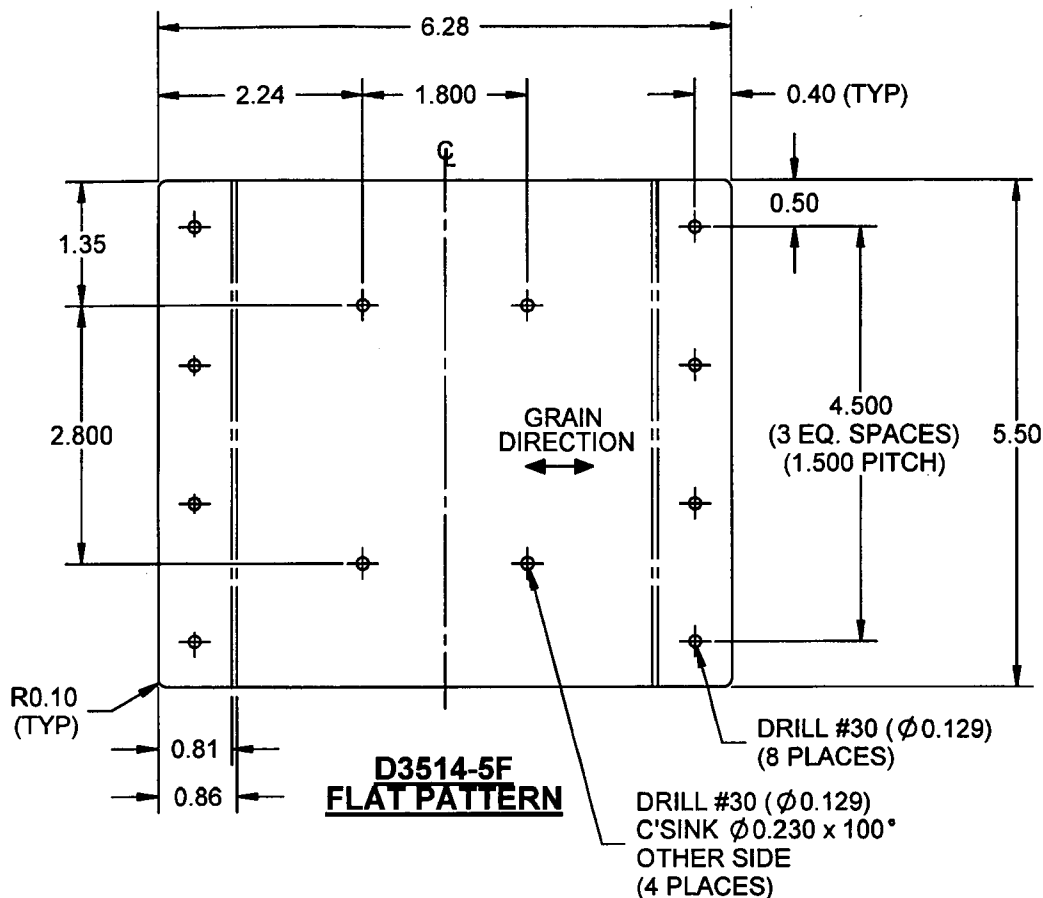
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DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514
DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 7 OF 9 SCALE 1:2



D3514-5 BOX BOTTOM (BOTTOM MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C
- 7) C'SINK ABOVE JOGGLE

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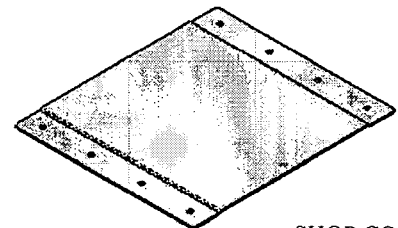
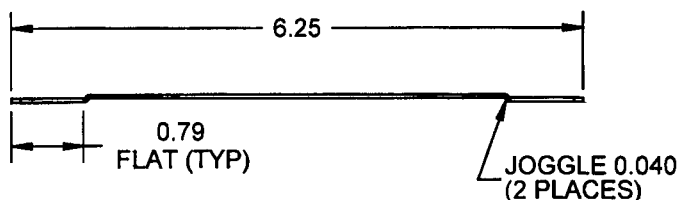
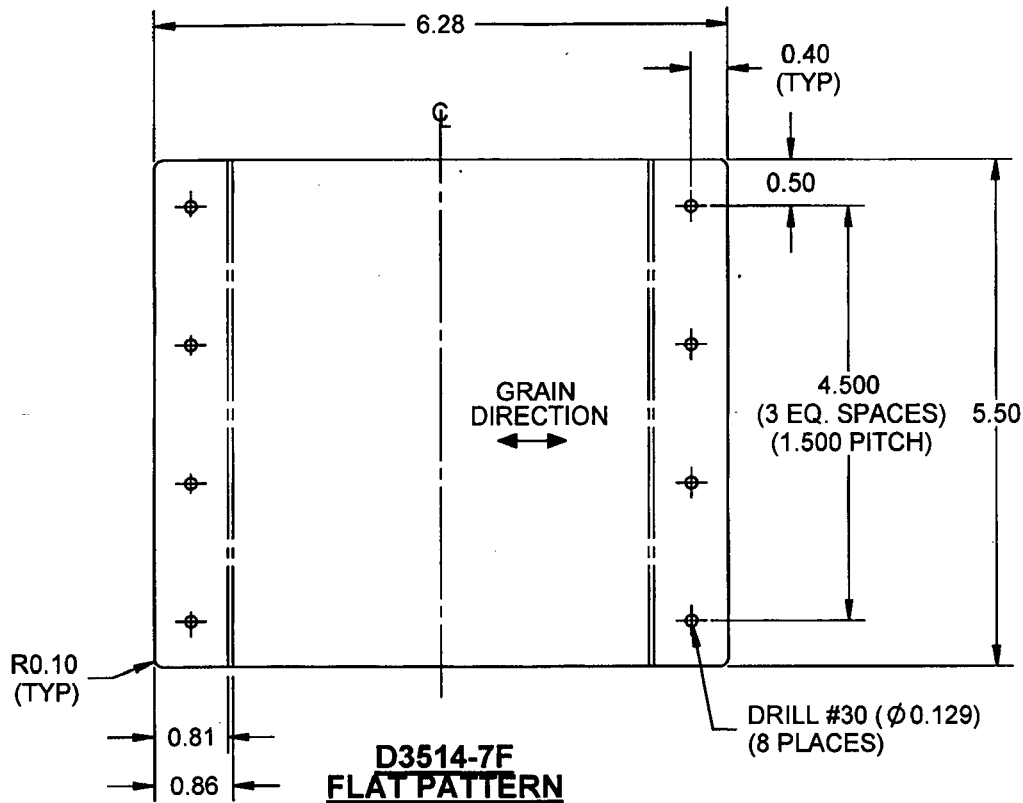
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DART

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3514	REV. A SHEET 8 OF 9
DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:2



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NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
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- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT Q

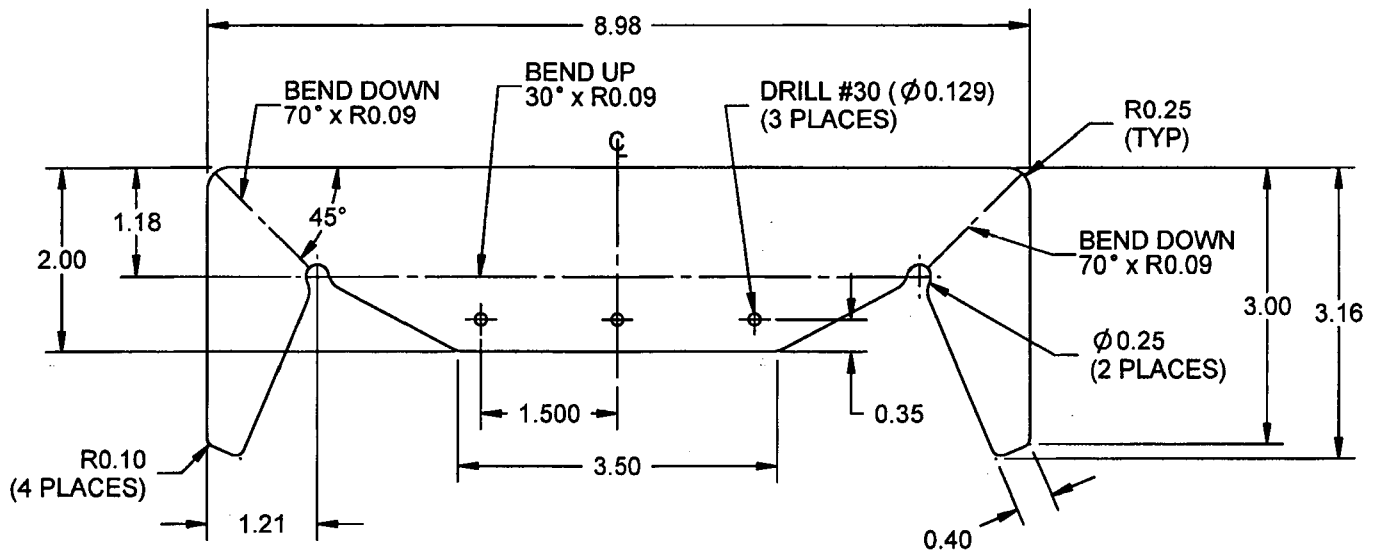
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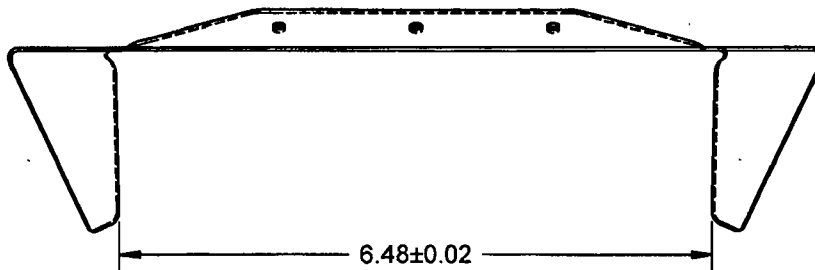
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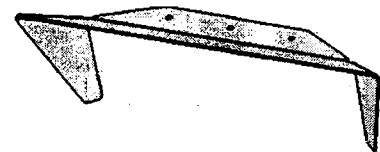
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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514	REV. A SHEET 9 OF 9
DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:2



D3514-9F
FLAT PATTERN



FRONT VIEW



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07-08-03 **[Signature]**

D3514-9 HOOD

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
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- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

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